

Date: Wednesday, 22/11/2006 1:53:27 PM
User: Linda Lacelle

Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BASKET (A119) ARMS |
| Job Number | : 29613 | | |
| Estimate Number | : 12440 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D35183 |
| This Issue | : 22/11/2006 | Drawing Number | : D3518 PRELIMINARY |
| S.O. No. | : <i>pm</i> | Project Number | : N/A |
| Prsht Rev. | : NC | Drawing Revision | : A PRELIMINARY |
| First Issue | : 21/11/2006 | Material | : <i>N/A</i> |
| Type | : R & D SM/MED FAB | Due Date | : 28/11/2006 |
| Previous Run | : 29548 | Qty: | 12 |
| Written By | : <i>[Signature]</i> | Um: | Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : EST rev. A 05.06.06 preliminary EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0875X06000 | 6061-T6 Bar 875" x 6.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 1.6387 f(s)/Unit Total: 19.6648 f(s)
6061-T6 Plate .875" x 6.0"
Batch: _____

pulled for 2 u

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3518
Dwg Rev: _____
Prog Rev: _____

2-Open holes to finish size as per Dwg D3518

3-Deburr if necessary

*could not remove
as it was already
scored on*

| | | |
|-----|---------|---------|
| 3.0 | 2458K14 | rod end |
|-----|---------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
rod end

| | | |
|-----|----|------------|
| 4.0 | PG | PURCHASING |
|-----|----|------------|



Comment: Issue P/O: *2543*
Purchase Part Number: 2458K14
Supplier: Mc Master Carr
Certificate of conformity is required

c 2006/11/22

(12)

Date: Wednesday, 22/11/2006 1:53:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 29613

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

10/6/11/04 (12)

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11 06-12-01 12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

SAD 06-12-02 12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12
06/12/04

Job Completion



11 06-12-04

Date: Tuesday, 11/21/2006 1:33:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29613
 Estimate Number : 12440
 P.O. Number :
 This Issue : 11/21/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run : 29548
 Written By :
 Checked & Approved By :
 Comment : EST,rev.A 05.06.06 preliminary EC

Drawing Name : BASKET (A119) ARMS
 Part Number : D35183
 Drawing Number : D3518 PRELIMINARY B
 Project Number : N/A
 Drawing Revision : A PRELIMINARY B
 Material :
 Due Date : 11/28/2006 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0875X06000 6061-T6 Bar 875" x 6.0"



Comment: Qty.: 1.6387 f(s)/Unit Total : 19.6648 f(s)
 6061-T6 Plate .875" x 6.0"
 Batch: M101323 ml 02 11 22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3518
 Dwg Rev: _____
 Prog Rev: _____
 2-Open holes to finish size as per Dwg D3518
 3-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Wrong
see dwg
only 1 used

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:33:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 29613

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

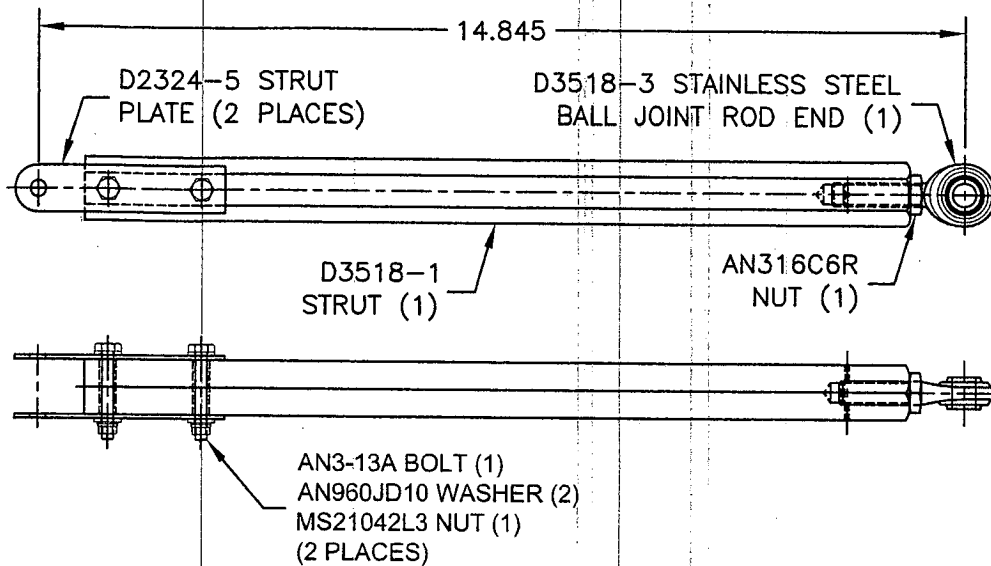
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 1 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:3 |
| A | 06.06.21 | NEW ISSUE | |
| B | 06.10.23 | RE-DESIGN | |



D3518-041 STRUT ASSEMBLY

| QTY -041 | Part Number | Description |
|-------------|-------------|------------------------------------|
| X | D3518-041 | STRUT ASSEMBLY |
| 2 | D2324-5 | STRUT PLATE |
| 1 | D3518-1 | STRUT |
| 1 | D3518-3 | STAINLESS STEEL BALL JOINT ROD END |
| 2 | AN3-13A | BOLT |
| 1 | AN316C6R | NUT |
| 4 | AN960JD10 | WASHER |
| 2 | MS21042L3 | NUT |

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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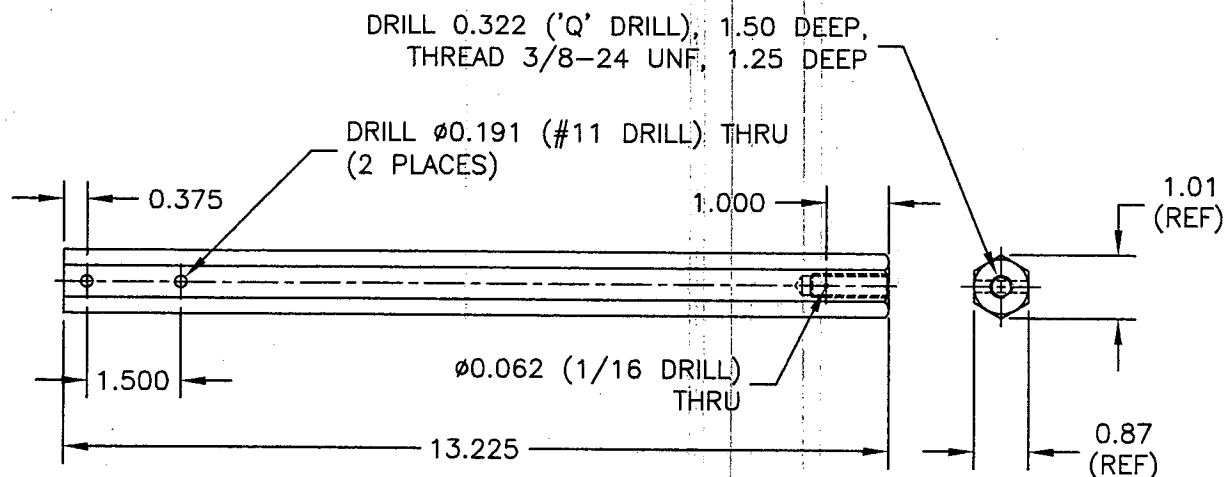
06.11.17 *[Signature]*

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|------------------|------------------------------|---|------------------------|
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| CHECKED PH | APPROVED [Signature] | DRAWING NO. D3518 | REV. B SHEET 2 OF 3 |
| DATE 06.10.23 | TITLE BASKET (A119) STRUT | | SCALE 1:3 |



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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06.11.17 [Signature]

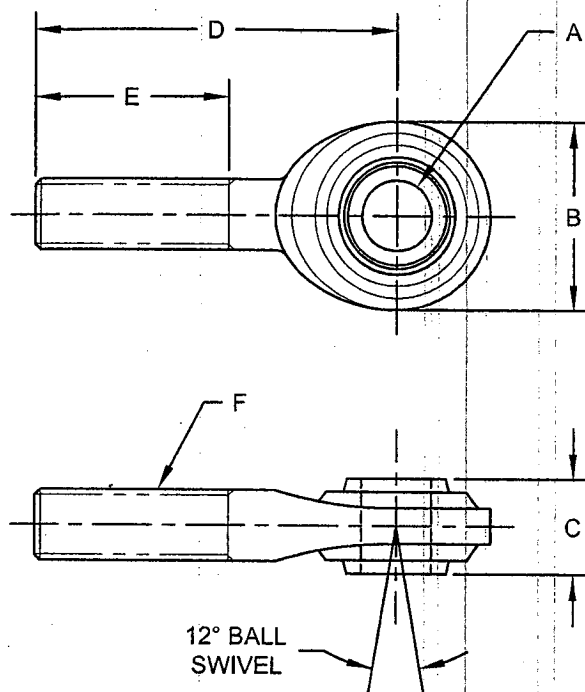
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|----------------------|--------------------------------|---|------------------------|
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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 3 OF 3 |
| DATE 06.10.23 | TITLE BASKET (A119) STRUT | | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING



| DART P/N | A | B | C | D | E | F | LOAD* | POSSIBLE SUPPLIER |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3 | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24 UNF, RH | 4012 | McMASTER-CARR, P/N 2458K14 |

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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| Warehouse Location | McMaster Carr Part Number | Fill Quantity | Item Description | Your Line | Your Order | This Shipment |
|---|---------------------------|---------------|---|-----------|------------|---------------|
| 3-297-07 30-83 | 2458 K141 | 12 EA | CARBON-FIBER RACE BALL JOINT ROD END 3/8"-24 RH MALE SHANK, 4012 POUND LOAD CAPACITY SAME AS 2458K14 <div style="text-align: right;">1</div> | 1 | 12 EA | 12 |
| <div style="position: absolute; top: 10px; left: 10px; font-size: 2em; font-family: cursive;">u</div> <div style="position: absolute; top: 10px; left: 40px; font-size: 2em; font-family: cursive;">u</div> <div style="position: absolute; top: 10px; left: 45px; font-size: 1.5em;">06.12.01</div> <div style="position: absolute; bottom: 10px; left: 30px; opacity: 0.5;"> MA/MASTER-CARR PACKING LIST </div> | | | | | | |